

Date: Monday, 28/04/2008 8:14:00 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 38822	
Estimate Number : 10678	
P.O. Number :	Part Number : D3443043
This Issue : 28/04/2008 S.O. No. :	Drawing Number : D3443 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 37089	Material :
Written By :	Due Date : 10/05/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 08.4.28</u>	
Comment : EST. REV. A 05.11.17 NEW ISSUE EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34437	Tubing
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-7	TUBING	<u>640625</u>

2.0	D34433	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-3	CLEVIS	<u>1340561</u>

EL 8-12-5 x4

EL 8-12-5 x4

3.0	238805	SS DOWEL PIN 3/4" LONG
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	238-805	SS DOWEL PIN 3/4" LONG	<u>M105037</u>

EL 8-12-5 x4

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3443

M107051 SS TIG ROD

EL 8-12-5 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:14:00 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 38822

Part Number: D3443043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/12/05 (4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/08/12/05 (4x)

7.0

POWDER COATING

POWDER COATING



M109152



(4x)

Comment: POWDER COATING

1-Mask holes as per dwg D3443 11/8-12-09 (4x)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20  
400 °C  
10:50

M-11 08/12/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-09 (4x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SB

08/12/10 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/11 11

Job Completion



MF 08-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

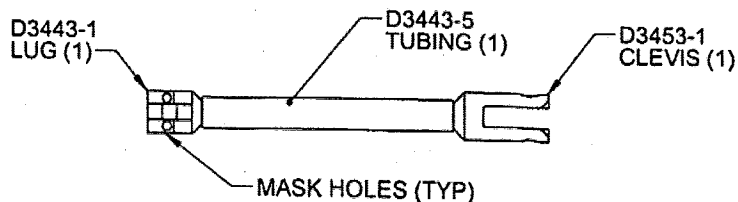
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

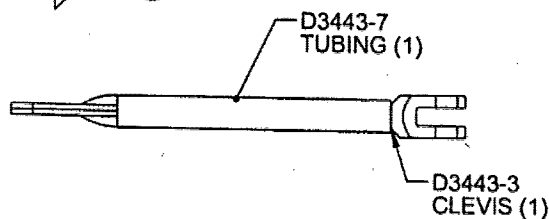
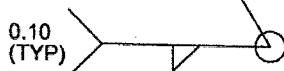
NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

**RELEASED**05.12.09 *H*PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT

8.54

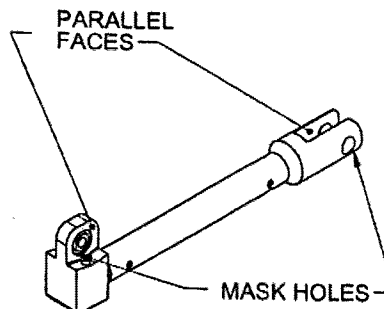
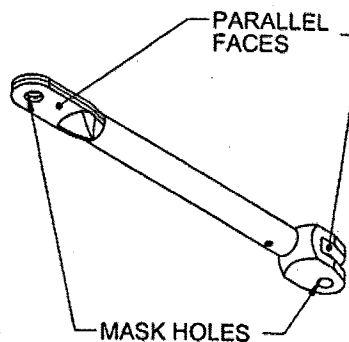
INSTALL SPAENAUER  
P/N 238-805 DOWEL PIN  
(TYP)0.10  
(TYP)INSTALL SPAENAUER P/N 238-805  
DOWEL PIN

9.78

0.10

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-041****D3443-043**

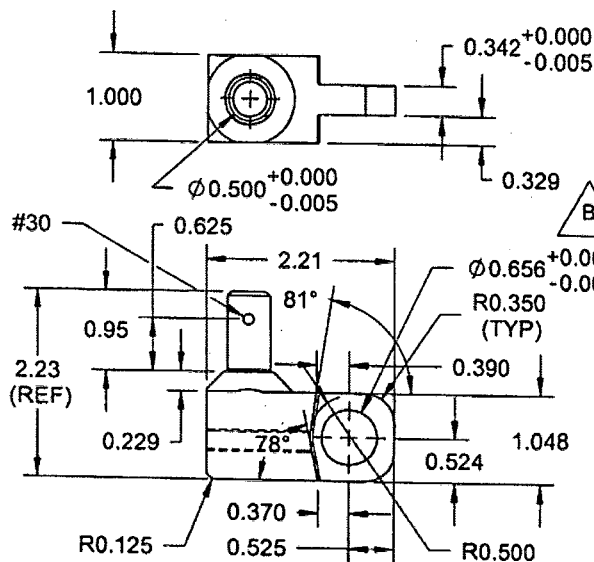
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

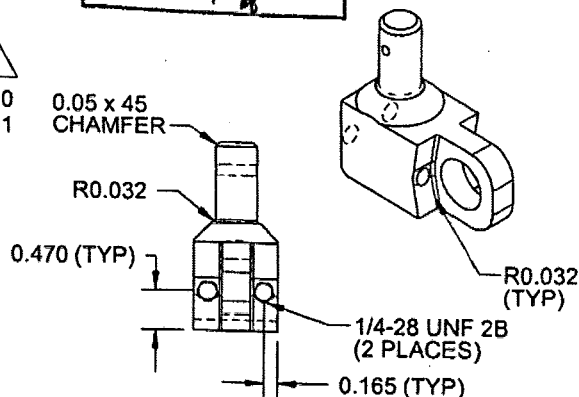


**D3443-1 NOTES:**

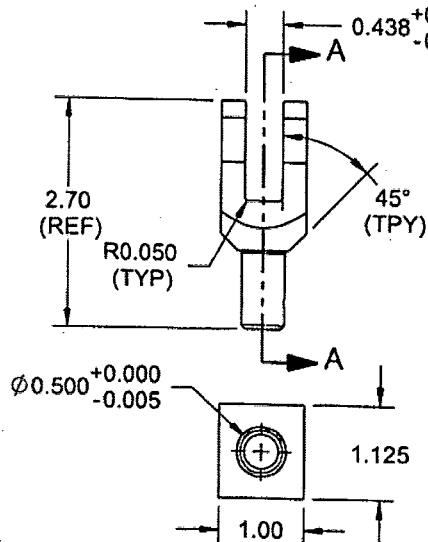
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**RELEASED**

05.12.04 #



**D3443-1 LUG**

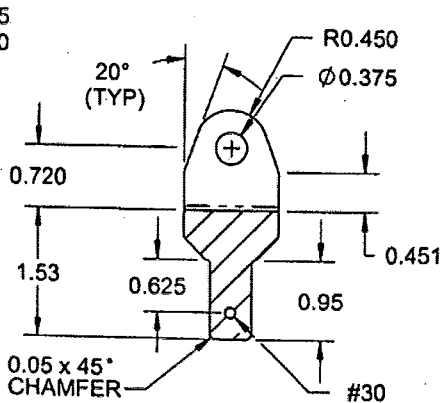


**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

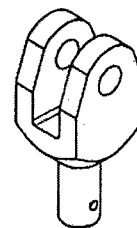
**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010



**SECTION A-A**

**D3443-3 CLEVIS**



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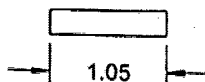
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 3 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



**D3443-9 PIN**

**D3443-9 NOTES:**

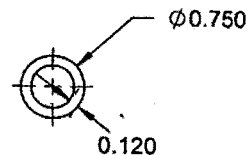
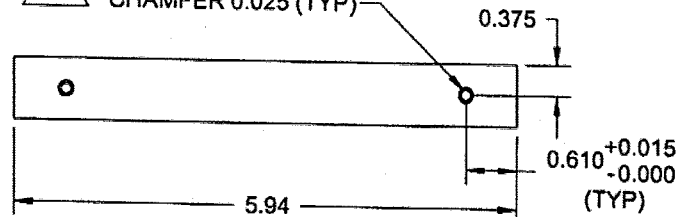
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.09 *[Signature]*

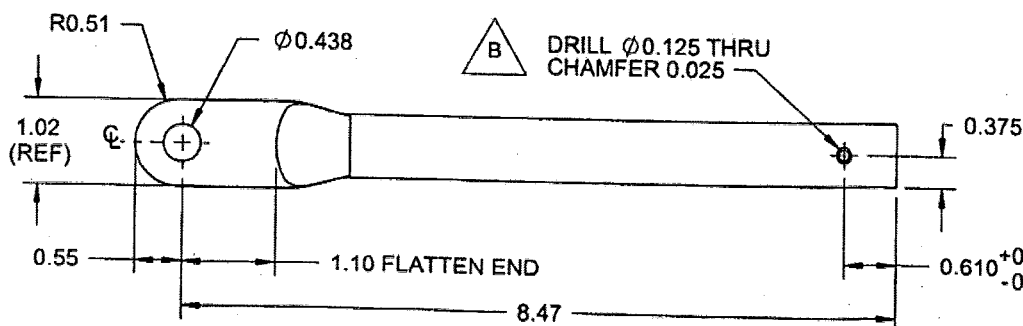
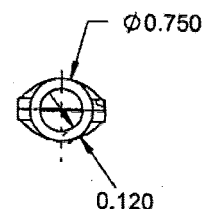
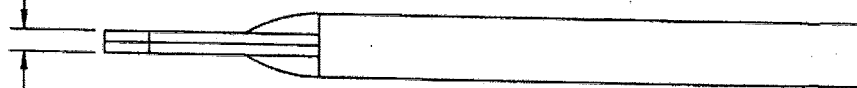


DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)



**D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$



**D3443-7 TUBING**

**D3443-5/7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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